



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3573-1
Job Sheet 169164



Part No: D3573-1

Job Qty: 4 ea

Part Name: Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/4/17

Job Tracking No:

Due Date: 12/22/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/21/17	0.00	0.00	Start Up Machining-2		<i>[Signature]</i>
100	Bandsaw	4 pcs		12/21/17	0.00	0.03	Bandsaw1		<i>[Signature]</i>
110	CNC Vertical Machining	4 pcs		12/21/17	0.42	0.68	HAAS1-4		<i>[Signature]</i>
120	QC	4 pcs		12/21/17	0.00	0.00	QC2 Machining-2		<i>[Signature]</i>
130	QC	4 pcs		12/21/17	0.00	0.00	QC8 Machining-2		<i>[Signature]</i>
140	HandFinish	4 pcs		12/21/17	0.00	0.14	HandFinish1		<i>[Signature]</i>
150	Powdercoat	4 pcs		12/22/17	0.00	0.13	Powdercoat3		<i>[Signature]</i>
160	QC	4 pcs		12/22/17	0.00	0.00	QC3		<i>[Signature]</i>
170	Packaging	4 pcs		12/22/17	0.00	0.00	Packaging3-1		<i>[Signature]</i>
180	QC21-SA	4 Ea		12/22/17	0.00	0.00	QC21		<i>[Signature]</i>

Part Op 100 - Cut blank 3.500" long

Descriptions: 110 - Machine as per Folia FA672 and Dwg D3573

150 - START TIME: *5.20* *OUT 3.20" FINISH 9.00.* *MB630*

170 - LOCATION : GA

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.625X02.500	1	11	0	0

Part Specifications

Specifications could not be found.

Plex 12/4/17 11:10 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Engineering ☐ Quality ☐ Other ☐																																													
Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com S019722 Adapter																																													
Description Work Order Deviation																																																	
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Environment ☐</td><td style="width:50%;">No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Pressure/Forced ☐</td><td style="width:50%;">Ten ☐</td></tr> <tr><td>Bending ☐</td><td>Set ☐</td></tr> <tr><td>Centre Not Concentric ☐</td><td>BO ☐</td></tr> <tr><td>Cracks ☐</td><td>Br ☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave ☐</td><td>Ins ☐</td></tr> <tr><td>Cuffs ☐</td><td>Co ☐</td></tr> <tr><td>Crushing ☐</td><td>Co ☐</td></tr> <tr><td>Heat Treat ☐</td><td>Cu ☐</td></tr> <tr><td>Wave/Twist in Tube ☐</td><td>Ins ☐</td></tr> <tr><td>Marks/Chatter ☐</td><td>Drill Holes ☐</td></tr> </table>		Pressure/Forced ☐	Ten ☐	Bending ☐	Set ☐	Centre Not Concentric ☐	BO ☐	Cracks ☐	Br ☐	Crimp/Kink/Ripple/Wave ☐	Ins ☐	Cuffs ☐	Co ☐	Crushing ☐	Co ☐	Heat Treat ☐	Cu ☐	Wave/Twist in Tube ☐	Ins ☐	Marks/Chatter ☐	Drill Holes ☐	D3573 - 1 Start up Operation Mfg Date: 12/11/17 Job No: 169164 PART NO: Revision: Operation: Change No:	
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				3 (QSI042) Approval _____ Completed By _____ id hand / Supervisor approval Verification _____ QC / QA Coordinator Approval _____ Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence																																													

DART AEROSPACE LTD		Work Order: 169164
Description: Adapter		Part Number: D3573-1
Inspection Dwg: D3573 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	+/-0.030	3.312	/		Vern Mlob	
2.69	+/-0.030	2.690	/		"	
2.31	+/-0.030	2.310	/		"	
1.600	+/-0.010	1.597	/		"	
0.36	+/-0.030	0.359	/		"	
1.19	+/-0.030	1.189	/		"	
2.38	+/-0.030	2.379	/		"	
1.420	+/-0.010	1.418	/		"	
0.48	+/-0.030	0.476	/		"	
R0.63	+/-0.030	R0.63	/		R-6	ref.
R0.13	+/-0.030	R0.13	/		"	"
R0.02	+/-0.030	R0.015	/		"	"
Ø0.209	+0.005/-0.001	0.210	/		Gage Pin	
Ø0.201	+0.005/-0.001	0.202	/		"	
0.520	+/-0.010	0.524	/		Vern Mlob	
Ø0.500 x 0.400	+/-0.010	0.499	/		Gages Pin	
Ø1.000 x 0.100	+/-0.010	1.003	/		"	

Measured by: FM/ML	Audited by: B.A	Prototype Approval:	N/A
Date: 17/12/14	Date: 17-12-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.04	New Issue	KJ/JLM	[Signature]